

Date: Monday, 27/04/2009 12:49:09 PM
 User: Julie Dawson

Process Sheet

Split

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ACCESS PANEL ASSEMBLY
Job Number	: 47496-2	Part Number	: D3245042
Estimate Number	: 13009	Drawing Number	: D3245 REV B
P.O. Number	:	Project Number	: N/A
This Issue	: 27/04/2009 S.O. No. :	Drawing Revision	: B
Prsht Rev.	: NC	Material	:
First Issue	: / /	Due Date	: 12/05/2009
Previous Run	: 45856	Type	: SMALL /MED FAB
Written By	:	Qty:	Um: Each
Checked & Approved By	: <u>JUD 09.04.27</u>		
Comment	: Est Rev :A New Issue 07-09-11 JLM Verified By:EC Est Rev:b ECN 1052 07-10-31 DD verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0	D32452	Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Panel
 Batch: B46172 (4x) B43902 (2x)

E/S 09/04/28

3.0	D32455	Door
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Angle Plate
 Batch: B43768 (4x) B46174 (2x)

E/S 09/04/28

4.0	235018C3Y	RIGID RECEPTACLE
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)
 RIGID RECEPTACLE
 Batch: M108722 (33x) M111129 (15x)

E/S 09/04/28

5.0	MS20427M33	Rivet
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)
 Rivet
 Batch: M110022

E/S 09/04/28

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 47496

Part Number: D3245042

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

MS20615M33

Rivet



EP 09/04/28

Comment: Qty.: 9.0000 Each(s)/Unit Total: 36.0000 Each(s)

Rivet

118235 (4x)

M108558

(50x)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Rivets and Nut Plates and D3245-5 angle as per Dwg D3245
be careful when countersinking...mat'l very thin

EP 09/06/11 (1)

EP 09/04/28 (6)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 09/06/11

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart P# and B# using fine point permanent ink marker and Stock
Location: _____

9/6/12

(12)

SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



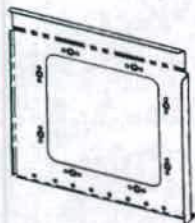
Comment: FINAL INSPECTION/W/O RELEASE

09/06/12

Job Completion

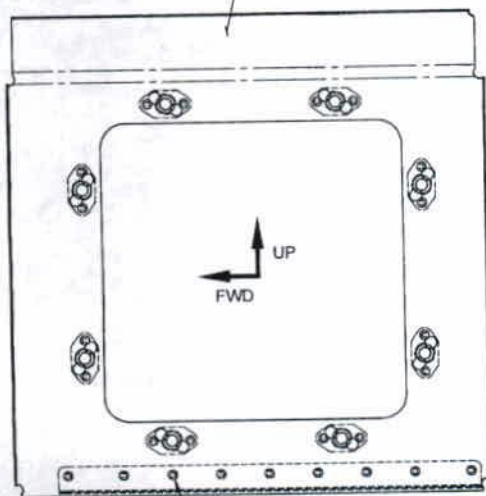


MF 09-06-12



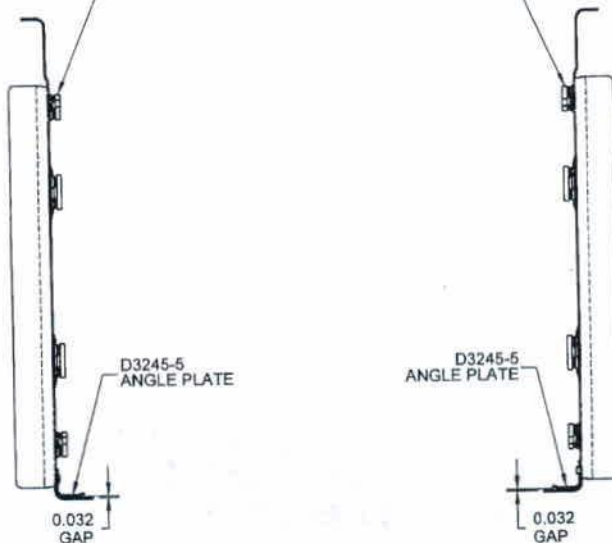
D3245-1
PANEL

2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)



MS20615M3-3 RIVET
(9 PLACES)

D3245-041 ACCESS PANEL ASSEMBLY

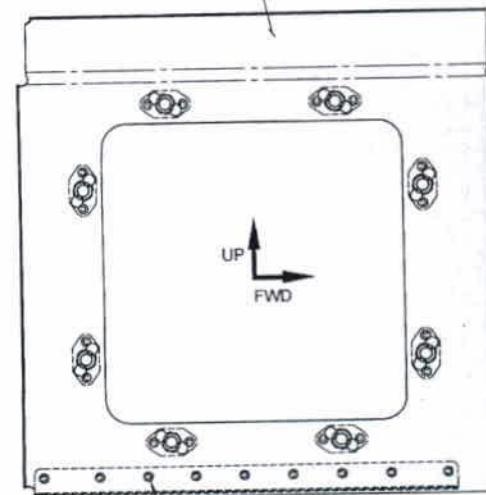
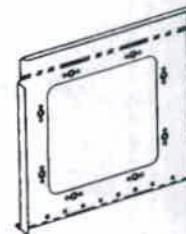


D3245-5
ANGLE PLATE

0.032
GAP

2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)

D3245-2
PANEL



MS20615M3-3 RIVET
(9 PLACES)

D3245-042 ACCESS PANEL ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSEMBLY, LH
	X	D3245-042	ACCESS PANEL ASSEMBLY, RH
1		D3245-1	PANEL
	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

RELEASED
107-10-23

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

B	REMOVE 8/0.204 HOLES FROM D3245-1/-2. REMOVE MS21060-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/-042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3245	SHEET 1 OF 7
APPROVED		TITLE	SCALE
DE APPR.		ACCESS PANEL ASSEMBLY	
DATE	07.10.02	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT PERMISSION FROM DART AEROSPACE LTD.	

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